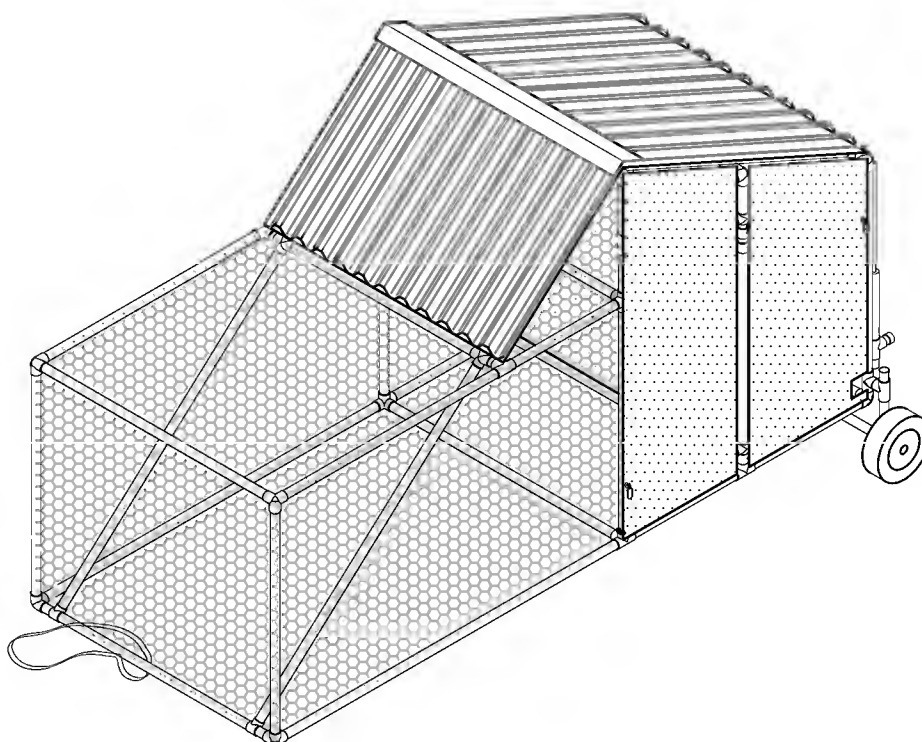


Portable Poultry Pen



Cover.....	Completed Pen
Page 1	Materials List
Page 2	Assembly Instructions, Nesting Box Detail & Bar / Holder Detail
Page 3	Main Frame
Page 4	Main Frame with Roof, Roosts, Doors & Wheel / Axle
Page 5	Finished Frame & Grizzly Panels
Page 6	Wheel Assembly Detail & Door Assembly Detail
Page 7	Roofing / Grizzly Panel Attachment & Latch Detail

Materials List:

All pipe is 1" Sch 40 PVC unless otherwise noted.

Quantity of pipe is approx. 163 l.f.

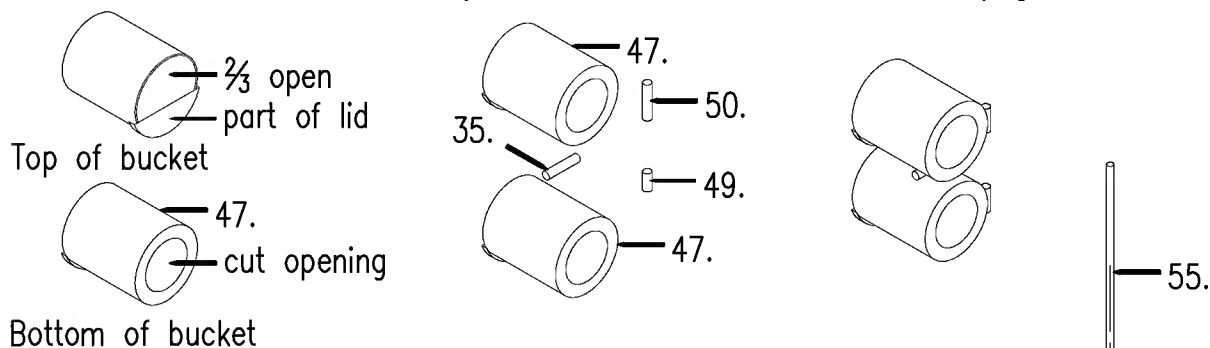
item	Qty	Description	item	Qty	Description
1.	4	67" Pipe	27.	1	40"x 3/4" EMT Conduit
2.	2	59" Pipe	28.	1	56"x1" Sch 80 Pipe
3.	100-200	J Clips	29.	1	1-1/4"x1" Sch 80 Pipe
4.	10	46" Pipe	30.	1	21-1/2" Pipe
5.	4	24" Pipe	31.	2	21-1/4" Pipe
6.	4	23" Pipe	32.	1	18" Pipe
7.	2	49" Pipe	33.	3	13" Pipe
8.	5	40" Pipe	34.	2	11-1/2" Pipe
9.	3	36" Pipe	35.	2	8" Pipe
10.	2	18-3/4" Pipe	36.	1	6" Pipe
11.	8	2-1/4" Pipe	37.	2	54" Pipe
12.	28	1" Slip-T's	38.	1	38-1/2" Pipe
13.	5	1" T's	39.	2	31" Pipe
14.	6	1" 90 deg. Elbow	40.	1	44" Pipe
15.	3	1" 45 deg. Elbow	41.	1	32-1/2" Pipe
16.	10	1" 3-way Connector	42.	1	9" Pipe
17.	6	1" 4-way Connector	43.	1	1" Cap
18.	1	1" 90 deg. Elbow - sch 80 or Furniture Grade	44.	2	4'x8' Grizzly Board Panels
19.	2	1" 4-way Cross	45.	2	8' x 26" or 28" wide Corrugated or Flat Metal Roofing
20.	1	24" long Nylon Strap	46.	1	Ridge Cap Metal 52" to 54" long
21.	1	6'x50' Roll Chicken Wire	47.	2	5 gal. Plastic Buckets
22.	50	5" Plastic Zip Ties	48.	2	5/8" x 1-1/2" Eye Bolt
23.		Self Tapping screws	49.	1	3"x1" Pipe
	50	1" @ roof & grizzly bd.	50.	2	6"x1" Pipe
	10	2" when screwing pipe to pipe	51.	1	1" Snap Clamp
24.	2	10" Pneumatic Wheels with 5/8" bearings	52.	1	1" T- sch 80 or Furn. Grade
25.	2	18"x5/8" Threaded Rod	53.	2	5/8" Nut
26.	2	8"x1/2" Sch. 40 Pipe	54.	4	5/8" Washer
			55.	1	19-1/2" x 3/4" EMT

Assembly Instructions :

1. Assemble base and uprights as shown on page 3. Check that all Slip "T"s are in place before glueing corners and ends.
2. Assemble upper frame and diagonals in one operation. Check for proper fit before glueing ends and corners.
3. Assemble doors as shown on page 4&6 and attach to Slip "T" hinges on the main frame.
4. Assemble axle and wheels as shown on page 6 and attach to main frame.
5. Assemble Nesting Boxes as shown below , and attach to main frame as shown on page 2 with self tapping metal screws.
6. Attach chicken wire to main frame using "J" clips at approx. 6" o.c.. When seaming the chicken wire panels together, use "J" clips at approx. 3"-6" o.c.. When terminating the chicken wire at a pipe frame, lap the wire around the frame and use "J" clips at approx. 6" o.c..
7. Cut grizzly board panels out to dimensions shown on page 5. Attach Grizzly Panel Boards as shown on page 7 with self tapping metal screws at approx. 6" o.c.. Use zip ties to attach the chicken wire to the grizzly board at the bottom of Panel E.
8. Attach the corrugated metal roof panels as shown on page 7 using self tapping metal screws at approx. 6" o.c.. Be sure to use the wider 28" metal panels and overlap 2" at the center.
9. Install Bar & Holder assembly to outside of Panel B and screw through top and bottom into the corner pipe. see page 7

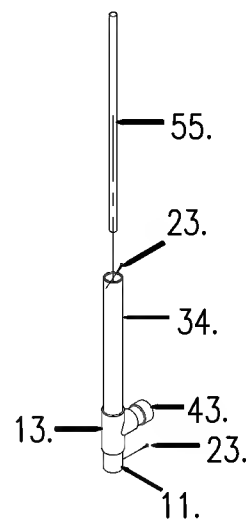
Nesting Box Assembly Instructions:

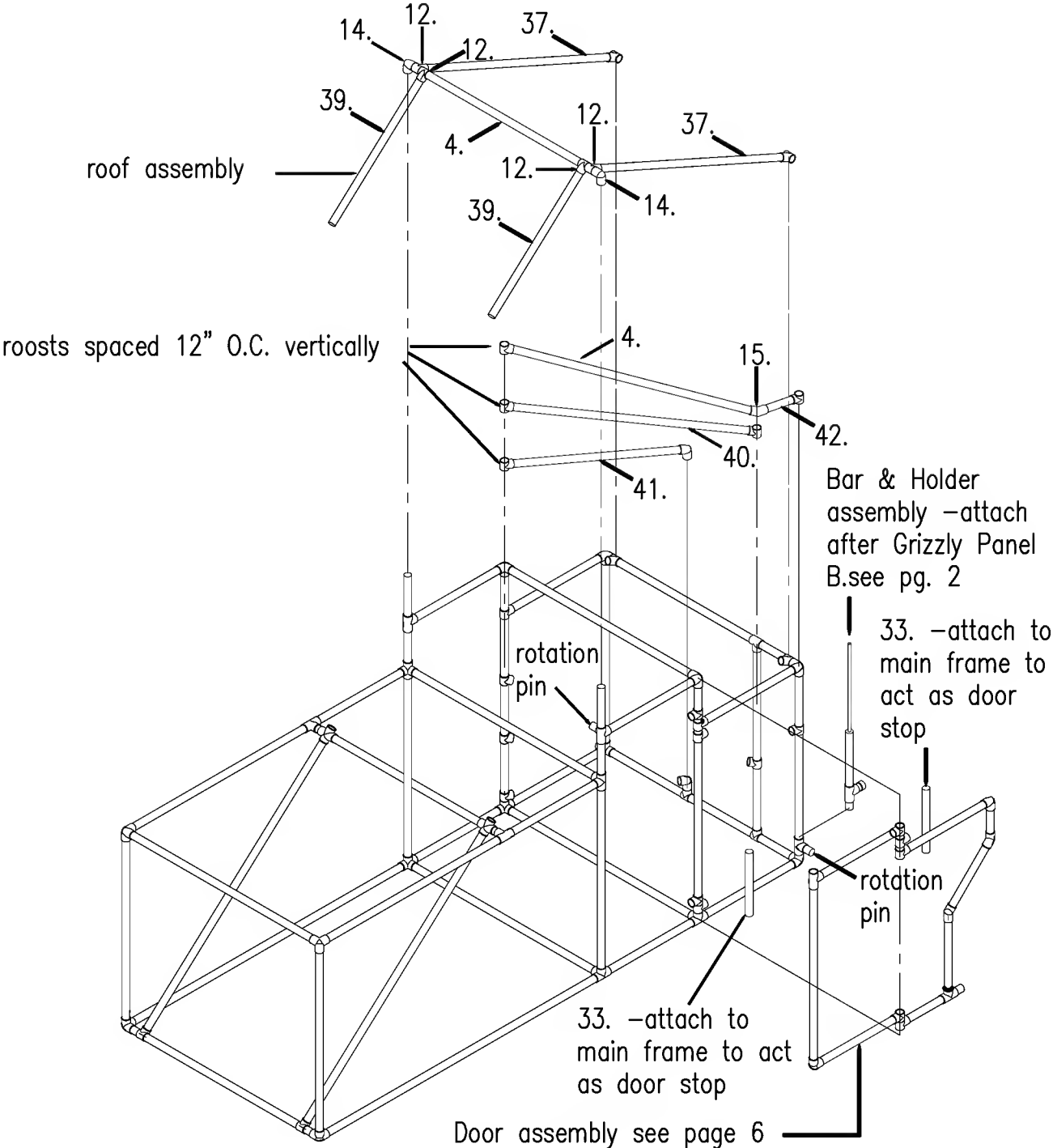
1. Take two 5 gal. plastic buckets and cut a hole in the bottoms as shown below and screw $\frac{1}{3}$ of the lid to the top as shown below, with $\frac{1}{2}$ " self tapping screws (3 equally spaced).
2. Screw the two buckets together; one on top of the other with a horizontal pipe spacer between them as shown below.
3. Screw vertical spacers to the sides of the buckets as shown below.
4. Attach the completed assembly to the main frame as shown on page 5.



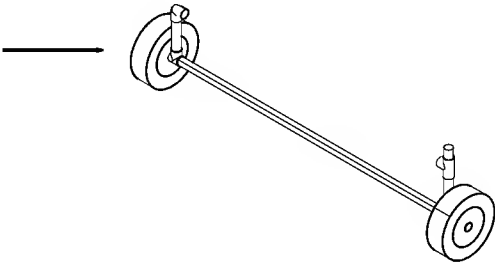
Enlarged Bar & Holder Assembly Instructions:

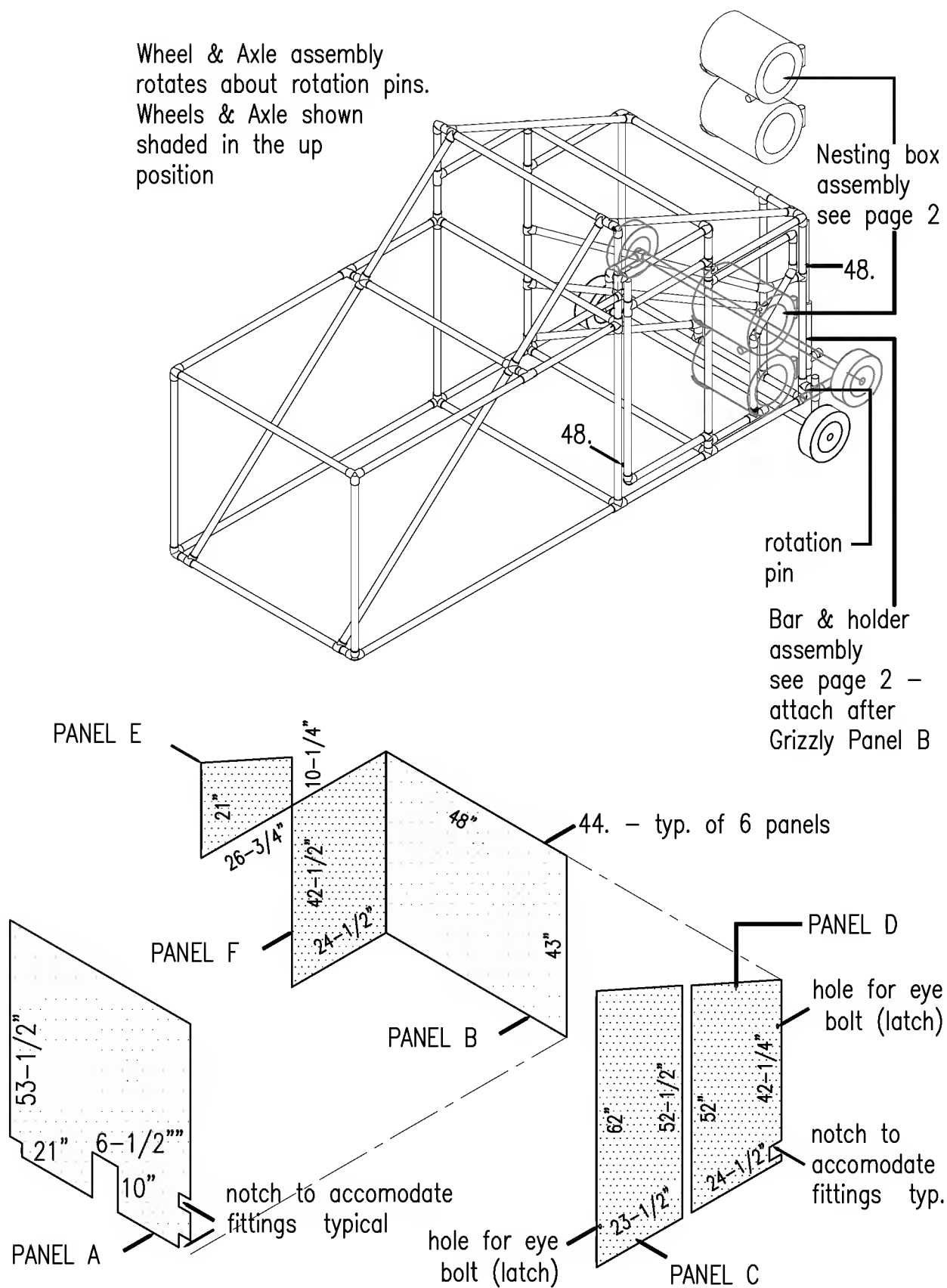
1. Assemble Bar & Holder assembly as shown after Panel B is installed. See page 5
2. Attach assembly to upright shown on page 4&5, using self tapping metal screws – one top & bottom – angle the top screw on the inside of the pipe pointing downward, so it doesn't obstruct the opening.





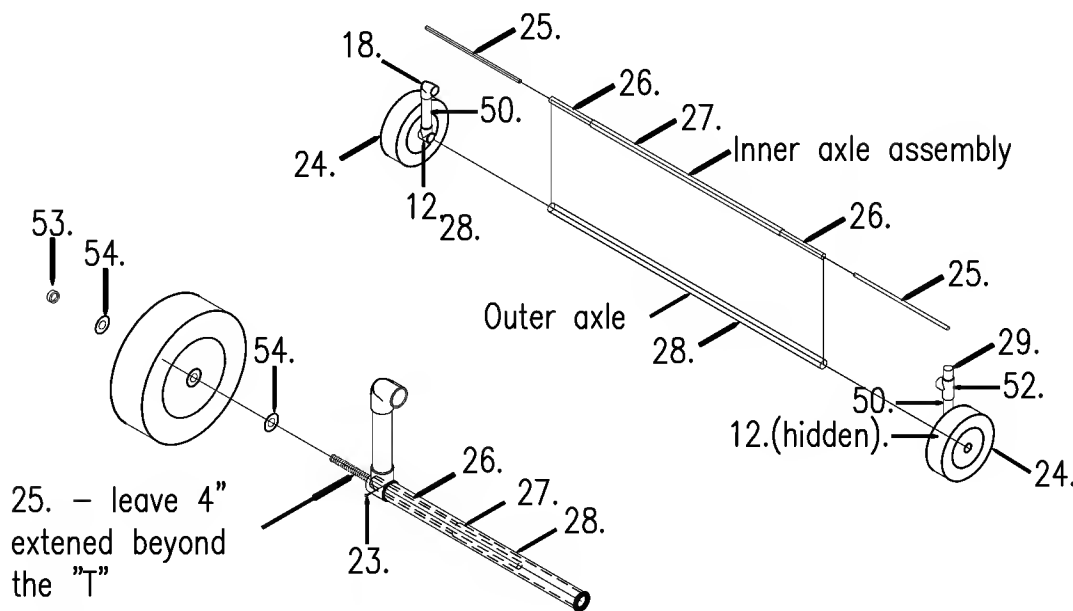
wheel and axle assembly see page 6





Wheel Assembly Instructions:

1. Install wheel assembly so item #52 item and #57 rotate freely on the item #11 rotation pins, so wheels rotate under or to the back of the poultry pen when bar #55 is used in the #29 fitting.
2. Place item # 52 and #57 on rotation pins.
3. Put axle assembly in place.
4. Screw through axle "T"s – item #12.
5. Bolt wheels into place.
6. Items #52. & #57. may be either sch 80 of furniture grade fittings. If sch 80 is used , sand inside of fittings to allow for smooth rotation.



Enlarged Axle Detail

Door Assembly Instructions :

1. Assemble door pieces as shown and attach to the slip "T"s . Slip "T"s act as hinges.
2. Glue Snap Clamp to vertical pipe just below the Slip "T"s.

